

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015974**Date Inspected:** 02-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 9CW and Seg 9DW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW9C-003. The welder's were identified as 066038, 067942 and 067765 and were observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS:

B-P-2214-B-U2-FCM-1. See attached photo for further details.

OBG Seg 9CE:

Repair welding on weld joint no: DP711A-001-011. Welding process was identified as SMAW. The welder was identified as 048659 and was observed welding in the 4F position. ZPMC QC was identified as An Qiang Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1. Repair welding was done as

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per Welding Repair Report (WRR): B-WR-14195 Rev-0.

OBG Seg 9DE:

Repair welding on weld joint no: DP712A-001-011. Welding process was identified as SMAW. The welder was identified as 048659 and was observed welding in the 4F position. ZPMC QC was identified as An Qiang Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14195 Rev-0.

Traveler Rail Brackets:

The Flux Cored Arc Welding (FCAW) process on weld joint no: TR5C-PP73-006. The welder was identified as 220069 and was observed welding in the 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4c-F.

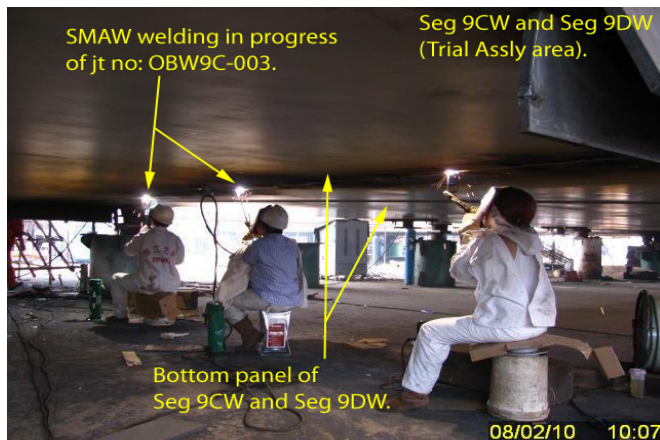
The FCAW process on weld joint no: TR6C-PP74-006. The welder was identified as 222369 and was observed welding in the 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4c-F.

The FCAW process on weld joint no: TR6B-PP78-004. The welder was identified as 204342 and was observed welding in the 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4c-F.

Cross Beam 12 (CB12):

This QA Inspector did random visual inspection of the welds of this CB. Visually, no significant discontinuities were observed. NDT / tagging of this CB is still to be done.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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